

INSTALLATION INSTRUCTIONS:
HD 4WD Engine Mounts B2-R Conversion
PART #3640



865.938.6696 www.dufftuff.com
6609 Bronco Ln.
Knoxville, TN 37921

1/2 7/22

Installation Difficulty
5 out of 10

CONTENTS:

- 2 MOTOR MOUNTS
- 2 1/2" PLATED FLAT WASHER
- 2 1/2" PLATED NC NYLOC NUT

Please read all instructions completely before beginning. Refer to the detailed drawing on the back of the page.

Passenger Side

1. Measure from the center of the rear crossmember rivet of the passenger side frame rail, following the frame contour 4-7/8" toward the center of the crossmember. Scribe a line in the crossmember marking the center of the slot that will need to be cut. Measure from the rear of the crossmember at your mark of 4-7/8" forward on the cross member 1-5/8". Center punch where the measurements intersect. From your center punch mark measure 1" forward on your 4-7/8" scribe line and center punch again. Drill these to center punched marks to 5/8". **(Note: drill a 1/8" pilot hole and work up to 5/8")** Connect the 2 holes using a saw creating a slot in the crossmember. Debur the slot with a rat tail file or rotary file.

Drivers Side

2. Measure from the center of the rear cross member rivet of the drivers side frame rail, following the contour of the frame 5-1/2" towards the center of the crossmember. Scribe a line marking the center of the slot that will need to be cut. Measure from the rear of the crossmember at your mark of 5 1/2" forward on the crossmember 1- 3/16". Center punch where the measurement intersects. From your center punch mark measure 1" forward on your 5-1/2" scribe line and center punch again. Drill both center punched marks 5/8". Connect the 2 holes using a saw. Debur the slot.

Note: Before drilling any holes using a small rope holding it tight from the front drivers side scribe line to the passenger side scribe line. Make sure the 2 lines are level with each other. This will ensure the engine sets level in the chassis.

3. Bolt motor mounts into new slots.

4. After insuring their fit on the crossmember, bolt the mounts to the engine. Leaving the mounts loose, When you lower the engine into the vehicle. Be sure to tighten the nuts on the motor mount studs to 65 ft. lbs. as well as tightening the mounts to the engine to stock specifications.

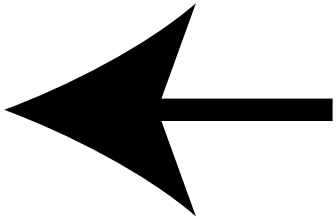
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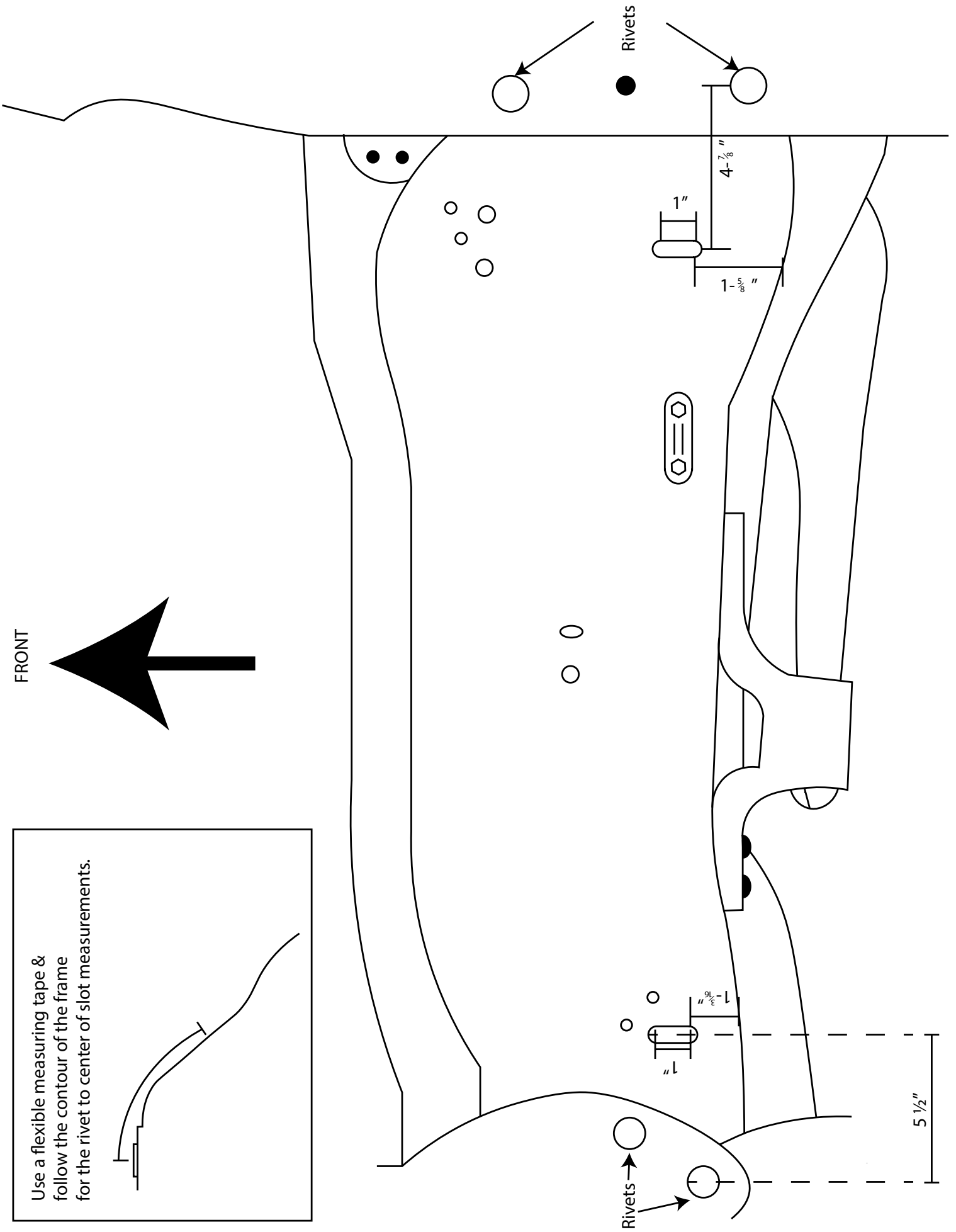
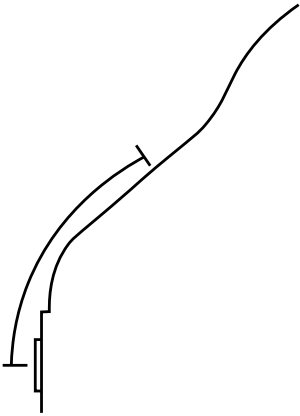
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FRONT



Use a flexible measuring tape & follow the contour of the frame for the rivet to center of slot measurements.



Rivets

Rivets



5 1/2"

4-7/8"

1-5/8"

1"



1"

1-3/16"

Rivets